

PRIVATE SPECIFICATION

prepared for



Utility Slacks, Women



CSS 286.21 G160
Version 01.0
June 2012

1. Scope

This specification covers the material and make of utility slacks for female personnel of Transnet Limited.

ITEM NUMBER: 35/163581

2. Definitions and abbreviations

For the purpose of this specification the definitions given in SANS 10371 "Terms and definitions for clothing" and the following shall apply:

acceptable: acceptable to Transnet Limited

nominal: subject to the tolerances normal to good manufacturing practice

SANS: South African National Standard

3. Style

The style is as follows:

- ♦ a plain waistband
- ♦ belt loops
- ♦ front pleats
- ♦ slide fastener fly
- ♦ two slanting side pockets
- ♦ two hip pocket
- ♦ embroidery on the right hip pocket
- ♦ reflective tape around legs
- ♦ plain bottoms
- ♦ buttons with corporate logo
- ♦ fitted with a contrast colour laid-on strip along the side seams and sewn to the back panel

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 2 of 22

4. Illustrations

Illustrations are not to scale and are for guidance only.



Figure 1 – Slacks, Front & Back

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 3 of 22

5. Client furnished materials

No materials will be supplied by Transnet Limited.

6. Component materials

The following materials shall be supplied and used by the manufacturer. Trim charts shall also be submitted by the manufacturer (see Annex A).

6.1 Outer material

- ♦ to be an acceptable 2/1 twill Poly/Cotton fabric
- ♦ of nominal mass 235 g/m² when tested in accordance with SANS 79
- ♦ fibre composition to be 65% Polyester and 35% Cotton when tested in accordance with SANS 1833-1 and 1833-11
- ♦ resistance to pilling, colour fastness, dimensional stability requirements to comply with the relevant requirements as given in SANS 1387 -2
- ♦ finish to be such that it shall have a soft handle and shall be as agreed upon between the purchaser and supplier
- ♦ colour to be an acceptable black colour as agreed upon between the purchaser and supplier

6.2 Strip material

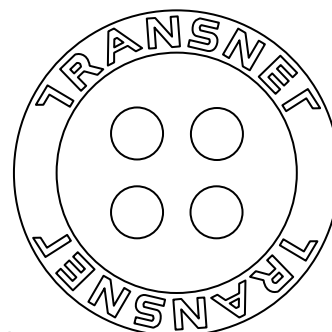
- ♦ to comply with the requirements as given in 6.1
- ♦ colour to be an acceptable match to Pantone Colour No. 376 "Olive green"

6.3 Slide fastener

- ♦ one-way closed end
- ♦ brass elements
- ♦ locking puller and slider
- ♦ to comply with the requirements for performance class B or C of SANS 1822 "Slide fasteners"
- ♦ colour of stringers to be an acceptable match to the colour of the outer material

6.4 Polyester buttons

- ♦ four-hole polyester
- ♦ nominal diameter of 17 mm
- ♦ to comply with the requirements of SANS 1457 "Plastics buttons"
- ♦ dope-dyed
- ♦ fully impregnated
- ♦ to have the Transnet logo engraved on the outer edges
- ♦ colour to be an acceptable match to the colour of the outer material



Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 4 of 22

6.5 Reflective tape

- ♦ a high visibility reflective silver tape
- ♦ nominal width 37 mm – 40 mm
- ♦ retro-reflective properties to comply with the relevant requirements for a class 2 retro-reflective material of SANS 50471 “High visibility warning clothing for professional use – test methods and requirements”

6.6 Embroidery thread

- ♦ an acceptable 100% Viscose machine embroidery thread
- ♦ colour to be an acceptable match to Pantone colour No 376 “Olive Green”

6.7 Interlining

- ♦ an acceptable fusible woven or non-woven interlining
- ♦ to comply with the requirements of CKS 627 “Fusible interlinings”
- ♦ mass per area shall be such that it is suitable for use in the fly
- ♦ suitable for use in garments which are to be washed
 - capable of withstanding the same washing and drying procedures as specified for the outer material

The selection of interlining of appropriate mass per area to be determined by consultation with the supplier of the interlining.

6.8 Threads

- ♦ to comply with relevant requirements of SANS 1362 “Sewing threads”
- ♦ colour to be an acceptable match to the colour with which it is used

Sewing and top-stitching thread:

- ♦ polyester-and-cotton core-spun or staple polyester
 - ♦ ticket No 80
- OR
- ♦ an acceptable alternative with a minimum breaking strength of 12N

Overlocking thread:

- ♦ crimp-textured polyamide or crimp-textured polyester
 - ♦ ticket No 80
- OR
- ♦ an acceptable alternative with a minimum breaking strength of 8N

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 5 of 22

7. Workmanship

The slacks to be:

- ♦ made with first-class workmanship throughout
- ♦ of uniform and acceptable make, colour and finish

To be free from:

- ♦ defects, that affect their appearance or may affect their serviceability (or both)
- ♦ marks
- ♦ spots
- ♦ stains, incurred in the making-up

Seams and stitches to be:

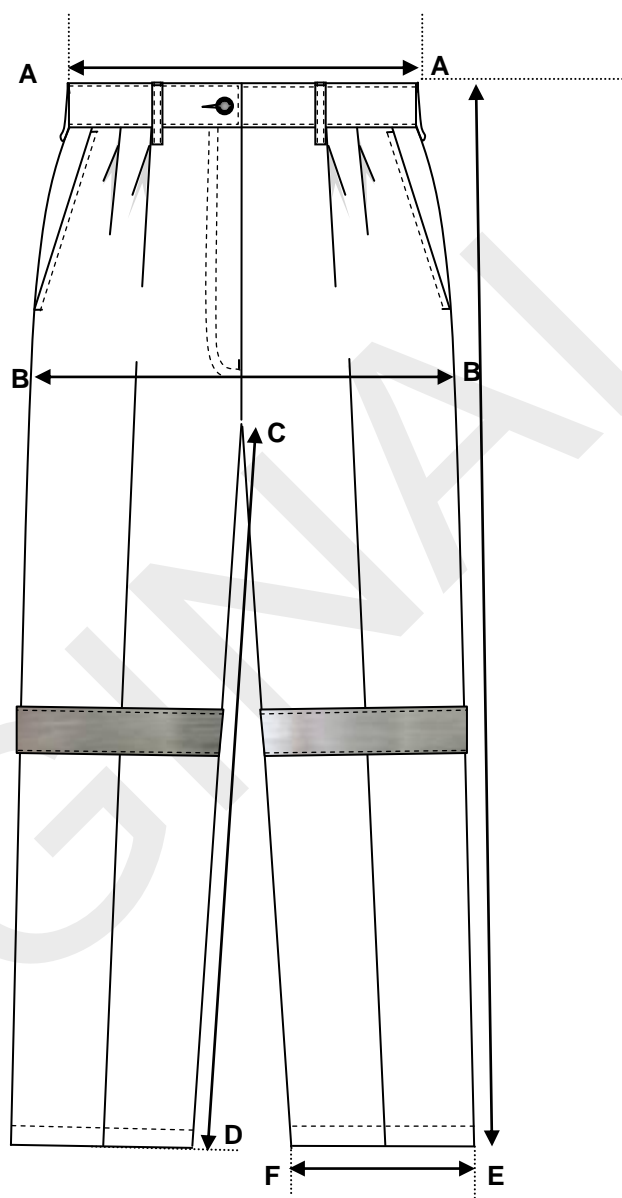
- ♦ smooth and uniform
- ♦ free from twists, pleats and puckers
- ♦ sufficiently extensible to avoid seam cracking and undue shrinkage in use

Ends of sewing to be:

- ♦ trimmed and loose threads removed
- ♦ back-tacked if unsecured

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 6 of 22

8. Sizes and dimensions



Measuring point		Description
A – A	Waist circumference	Measure across the top edge of the waistband and multiply by two.
B – B	Hip circumference	Measure across the width of the garment at hip level (widest point) and multiply by two.
C – D	Inside leg length	Measure from the crotch seam to the bottom edge of the garment.
A – E	Outside leg length	Measure from the top edge of the waistband to the bottom edge of the garment.
E – F	Bottom hem	Measure along the bottom edge of the leg and multiply by two.

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 7 of 22

Table 1 – Size range

1	2	3	4	5	6
Size designation ¹⁾	Nominal finished garment measurements, cm				
	Waist circumference	Hip circumference	Outside leg length	Inside leg length	Bottom hem circumference
26	55	90	106	80	42
28	60	95	107	80	42
30	65	100	107	80	42
32	70	105	108	80	42
34	75	110	108	80	42
36	80	115	109	80	42
38	85	120	109	80	42
40	90	125	109	80	44
42	95	130	110	80	44
44	100	135	110	80	44
46	105	140	111	80	44
48	110	145	111	80	44
50	115	150	112	80	44
52	120	155	112	80	46
54	125	160	113	80	46
56	130	165	113	80	46
58	135	170	113	80	46
60	140	175	114	80	46
62	145	180	114	80	46
64	150	185	114	80	46
1) Based on the bust circumference of the wearer in inches.					

9. Make

Illustrations are not to scale and are for guidance only, and unless inconsistent with the text, all measurements are nominal.

9.1 Fronts

Each front shall have:

- ◆ two pleats
 - reverse pleats
 - first pleat to be positioned in line with the crease line and stitched closed for a distance of 15 mm
 - second pleat to be positioned 35 mm behind the first pleat and stitched closed for a distance of 15 mm
 - each of finished depth 20 mm
- ◆ a slanted side pocket

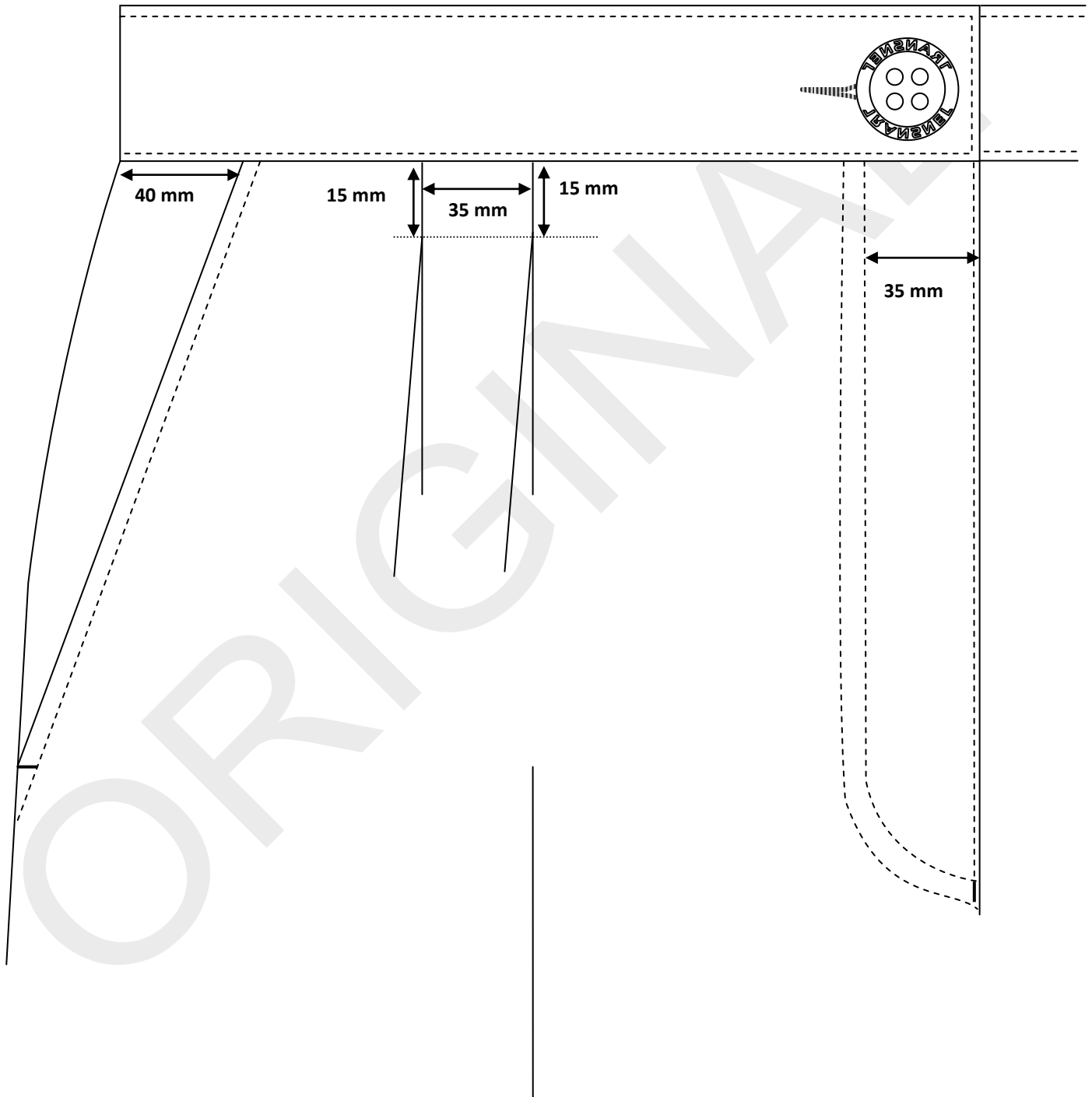
Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 8 of 22

Left front shall have:

- ♦ a fly-catch

Right front shall have:

- ♦ a fly



NOTE: Belt loops are omitted in this illustration.

Figure 2 – Right front

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 9 of 22

9.2 Fly

- ♦ lined with outer material
- ♦ interlined with interlining
- ♦ to be equipped with a slide fastener, sewn down 35 mm and 42 mm from the front edge
- ♦ front edge to be edge-stitched 1 mm
- ♦ raw edge to be overlocked
- ♦ the bottom of the fly to be securely finished off with a vertical bar tack

9.3 Fly catch

- ♦ to be of double folded outer material
- ♦ to be of finished width 35 mm (measured from the seam where stringer of the slide fastener is inserted to the outer edge of the fly-catch)

9.4 Waistband

- ♦ to be a continuous length of double folded outer material
- ♦ interlined with fusible interlining
- ♦ of finished width in the range of 35 mm to 40 mm
- ♦ edge-stitched 3 mm along all edges
- ♦ front edges to be boxed
- ♦ right front edge to be fitted with a buttonhole
 - slacks type buttonhole, gimped and of finished length 20 mm (length of slit opening)
 - positioned with front edge 10 mm from the free outer edge
- ♦ the left front edge to be fitted with a plastics button
 - in a corresponding position to the buttonhole

9.5 Belt loops

- ♦ each pair of slacks to have seven belt loops (see figure 6)
- ♦ loops to be of folded outer material, 12 mm wide and secured as follows:
 - one on each front pleat
 - one at each side seam (sewn to the back panel)
 - one at each back dart
 - one at the centre back
- ♦ the loops to be bar tacked approximately 10 mm below the waistband seam, turned up and bar tacked 2 mm from the top edge of the waistband
- ♦ the finished length of the belt loops to be 45 mm between the bar tacks

9.6 Backs

Each back shall:

- ♦ have a centrally positioned closed dart of finished length 80 mm
- ♦ have a hip pocket
- ♦ be fitted with a laid-on strip of contrast colour material
 - of strip material (see 6.2)
 - side edges to be turned in and edge-stitched 2 mm along both edges
 - of finished width 15 mm
 - positioned adjacent to the side seam and sewn to the back panel
 - top edge to be sewn in with waistband seam

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 10 of 22

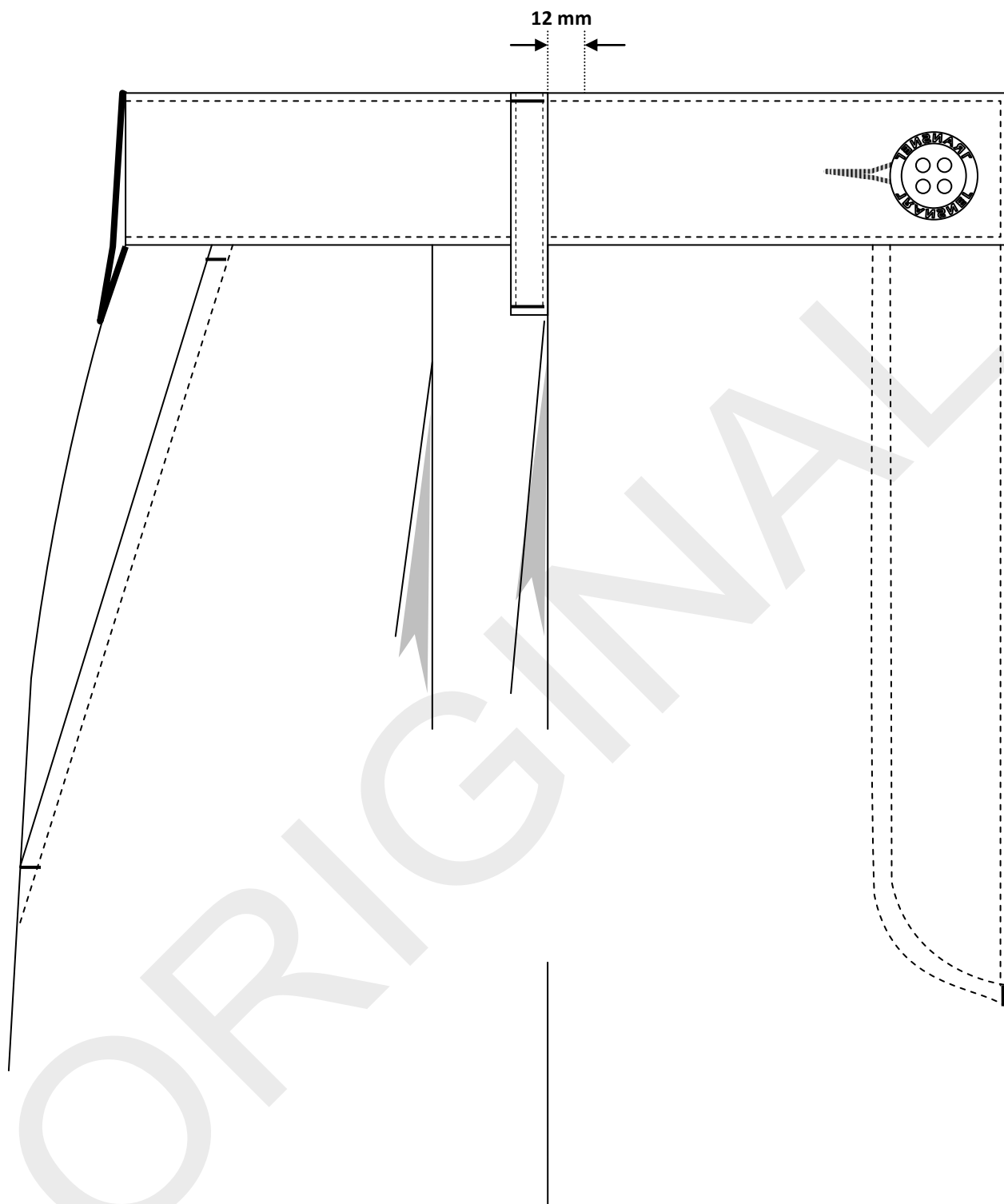


Figure 3 – Positioning of front belt loop

9.7 Pockets

- ◆ each slacks shall have two side pockets and two hip pockets
- ◆ all pocket mouth ends shall be securely finished off with bar tacks

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 11 of 22

9.7.1 Side pockets

- ◆ slanted mouth openings
- ◆ positioned 40 mm forward of the side seam
- ◆ mouth opening to be stayed with stay-tape or interlining
- ◆ edge-stitched 6 mm along the mouth opening
- ◆ to have a facing that shall extend along the full length of the mouth opening
 - facing to be a continuation of the front panels which are folded to the inside
 - raw edges of facing to be turned in and sewn on top of the outer pocket bag
- ◆ pocket bags to be of outer material
- ◆ top and bottom edges of mouth opening to be horizontally bar-tacked
- ◆ the dimensions shall be as given in table 2
- ◆ pocket bags to be bagged out
- ◆ upper ends of the side pockets to be carried into the waistband

Table 2 – Side pocket dimensions

1	2	3	4
Size designation	Width of pocket bag, minimum	Depth of pocket bag, minimum	Length of pocket mouth opening between the bar-tacks
	Measured below the lower bar tack		
All sizes	18 cm	14 cm	17 cm

9.7.2 Hip pockets

- ◆ each back panel shall be fitted with a hip pocket
- ◆ to be centrally positioned at the base of back darts
- ◆ to be patch pockets
- ◆ to have blunted corners of finished length 28 mm
- ◆ the dimensions of the pockets shall be as given in table 3
- ◆ the side and bottom edges shall be turned in 10 mm and edge-stitched 1 mm and 8 mm
- ◆ bar tacks on the outer edge of the pocket mouth shall be inserted horizontally between the edge-stitchings
- ◆ pocket mouth hem to be of finished depth 15 mm
- ◆ right hip pocket to be fitted with embroidery
 - embroidered with embroidery thread (contrast colour to the outer material)
 - the registered Transnet Logo to be centrally positioned in the pocket
 - dimensions to be as given in figure 4

Table 3 – Hip pocket dimensions

1	2	3
Size designation	Width of pocket bag	Depth of pocket bag
All sizes	16,5 cm	16 cm

NOTE: If the pockets do not fit on all sizes, deviations shall be as agreed upon between the purchaser and supplier.

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 12 of 22

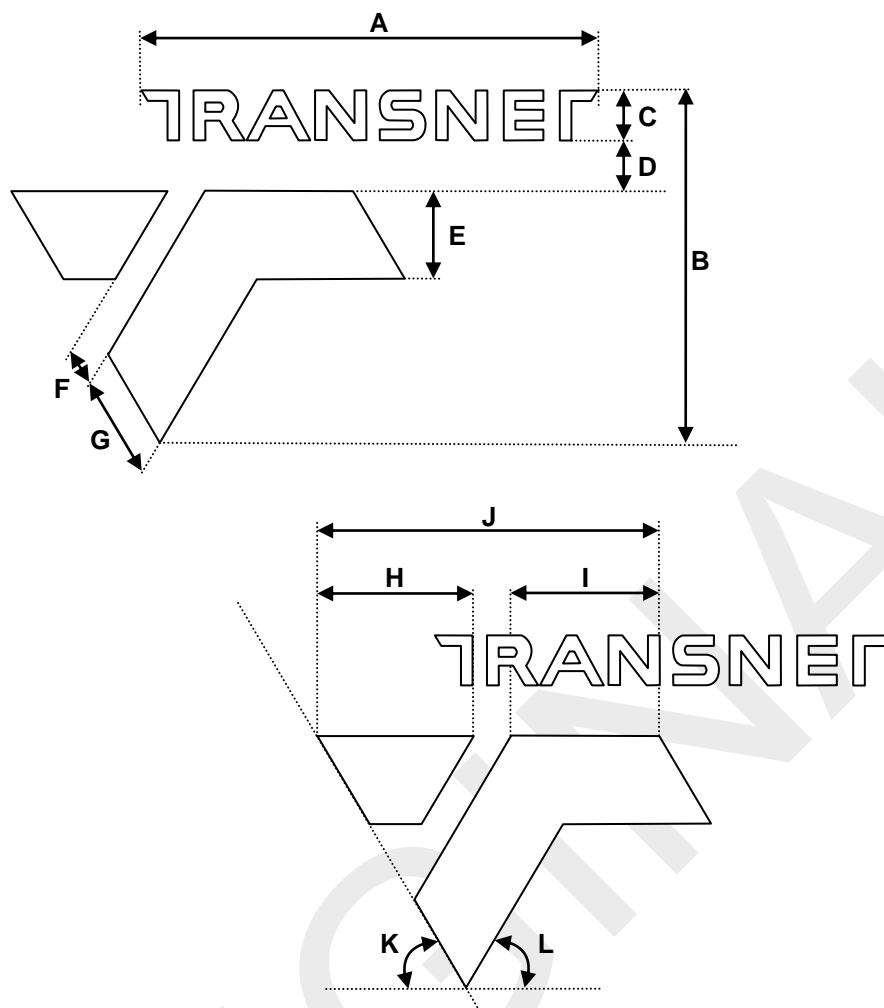


Figure No	Item	A	B	C	D	E	F	G
5		37 mm	32 mm	6 mm	6 mm	8 mm	2 mm	8 mm
	Item	H	I	J	K	L	-	-
		12 mm	12 mm	25 mm	60°	60°	-	-

Figure 4 – Dimensions of embroidered logo

9.8 Reflective strips

- ♦ sewn along the full circumference of the legs
- ♦ sewn in with the inside leg seams
- ♦ attached to the slacks legs by means of 2 mm edge-stitchings
- ♦ to overlap the contrast coloured side seam strips
- ♦ positioned in such a way that when the slacks leg is folded up in line with the crotch, the bottom edge of the reflective tape shall be positioned 10 mm above the foldline as given in figure 5

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 13 of 22

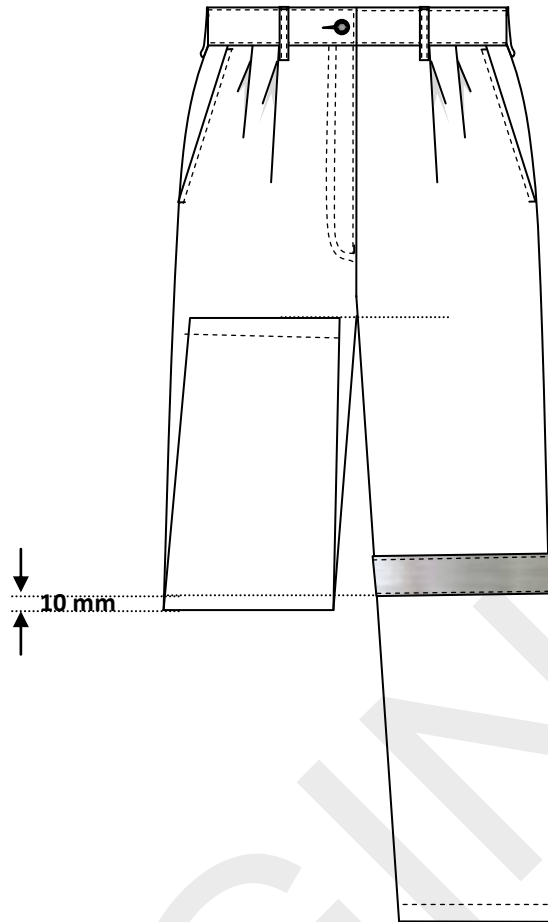


Figure 5 – Positioning of reflective tape

9.9 Bottoms

- ♦ to be plain
- ♦ folded in 20 mm and stitched down

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 14 of 22

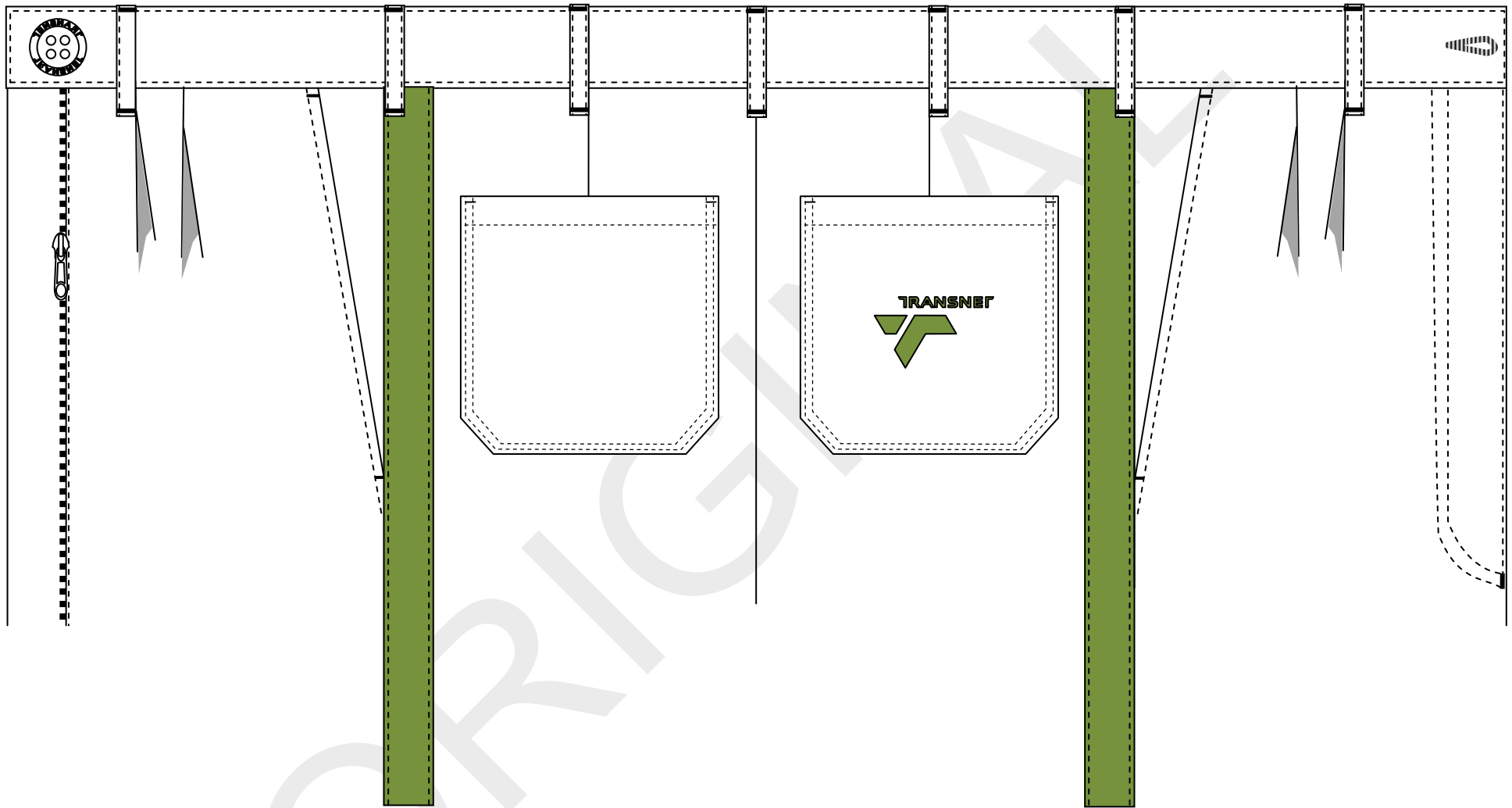


Figure 6 – Belt loop positioning

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 15 of 22

10. Stitches, seams and stitchings

10.1 Stitches

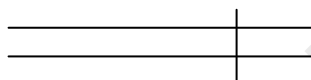
Side seams, leg seams and seat seams: safety stitch

Overlocking: three thread overlock stitch

Other sewing: single needle lock stitch

10.2 Seams

Outside leg seam and seat seam: seam type SSa



Superimpose two or more plies of material and seam with the appropriate number of rows of stitches positioned at the specified distance(s) from the aligned edges.

Side pocket bag edges: seam type SSe-2



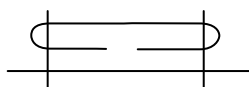
Form seam type SSa, using two plies of material. Then turn back each ply at the seam and seam through the turned edges with the appropriate number of rows of stitches.

Attachment of hip pockets: seam type SSb-2



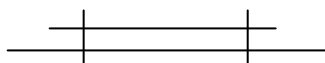
Turn in the specified width at the edge of one ply of material, superimpose it on a second ply, and seam through the turned edge with the appropriate number of rows of stitches.

Attachment of side seam strips: seam type SSat-2



Turn in the edges of a strip of material, superimpose it on a ply, and seam with the appropriate number of rows of stitches.

Attachment of reflective strips: seam type SSau-2



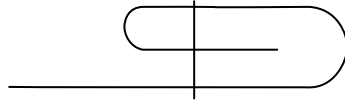
Superimpose a strip on a ply of material and seam with the appropriate number of rows of stitches.

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 16 of 22

Other seams: seam type SSa

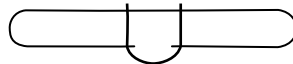
10.3 Stitchings

Hems and hip pocket hems: stitching type EFb



Turn in the specified width at the edge of a ply of material, fold back the turned edge, and stitch the turned-in and folded portion with the appropriate number of rows of stitches.

Belt loops: stitching type EFh



Turn in the edges of a strip of material, abut the edges, and stitch the abutted edges with one row of stitches that extends across and covers the edges.

10.4 Number of stitches

Seams: 40 ± 4 per 10 cm

Overlocking: 32 ± 2 per 10 cm

Buttonholes: 12 ± 1 per 1 cm

Buttons: 18 ± 1 per button

11. Care-labelling and marking

11.1 Label properties

All labels shall:

- ♦ be pink woven rayon labels that are printed
- ♦ comply with SANS 1309 "Printed labels for textiles"
 - information to be in legible and indelible block letters of height at least 3 mm
- ♦ permanently secured
- ♦ be such that they outlast the garments (including the markings)

11.2 Care-labelling

- ♦ each garment shall have a label that provides correct and appropriate care instructions (in words and symbols, in accordance with SANS10011 "Care-labelling of textile piece-goods, textile articles and clothing")
- ♦ each label to include the composition of the main fabric in accordance with the requirements of SANS 10235 "Fibre-content labelling of textiles and textile products"

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 17 of 22

11.3 Marking

- ♦ Each pair of slacks shall have, sewn in with the waistband **on the right front inside**, a label that provides the following information:
 - the word “TRANSNET”
 - the manufacturer's name of trade mark or both
 - the item number
 - the size designation
 - the spec number
 - the fibre composition of the body fabric
 - the country of origin
 - the year of manufacture
 - the VAT number of the contractor

TRANSNET

Manufacturer's name

ITEM NO:
35/000000

SIZE: 34

Spec No: CSS 286.21 G160

65% Polyester/35% Cotton

MADE IN SOUTH AFRICA

2012

VAT No: 4679312

Figure 7 – Example of information on label

12. Packaging and marking of packaging

12.1 Packing

12.1.1 The slacks shall be:

- ♦ delivered in a commercially dry condition
- ♦ so packed that they will not be damaged in transit or in storage
- ♦ neatly folded and individually packed in a plastics envelope of suitable size and shape
 - each pair of slacks shall be packed in the plastic envelope in such a way the right front edge is folded open to expose the label
- ♦ unless otherwise specified in the order or contract, acceptably packed for transportation in acceptable bulk containers

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 18 of 22

12.1.2 Slacks:

- ♦ of the same size designation to be packed together in a bulk container (unless quantities ordered are such that packing together of the same size is not justified)
- ♦ of different size designations may also be packed together to accommodate the last part of an order or contract

12.2 Marking

12.2.1 Envelopes

To be as specified in CSS 286.21 LAB/1.

12.2.2 Bulk containers

To be as specified in CSS 286.21 PAC/1.

12.3 Additional marking

When so required by the Transnet, slacks, envelopes or containers (or any combination of these) to bear information additional to that specified above.

13. Normative References

The following documents contain provisions which, through reference in this text, constitute provisions of this specification. All documents are subject to revision and, since any reference to a document is deemed to be a reference to the latest edition of that document, parties to agreements based on this specification are encouraged to take steps to ensure the use of the most recent editions of the documents indicated below. Information on currently valid national, international and CKS documents may be obtained from Standards South Africa*.

CKS 627, *Fusible interlinings.*

CSS 286.21 LAB/1, *Labelling.*

CSS 286.21 PAC/1, *Packaging.*

SANS 79, *Textiles - Mass per unit area of conditioned fabrics.*

SANS 1309, *Printed labels for textiles.*

SANS 1362, *Sewing threads.*

SANS 1387-2, *Woven cotton and similar apparel fabrics – Part 2: Polyester-and-cotton workwear fabrics.*

SANS 1457, *Plastics buttons.*

SANS 1822, *Slide fasteners.*

SANS 1833-1/ISO 1833-1, *Textiles – Quantitative chemical analysis – Part 1: General principles of testing.*

* **Standards South Africa: Tel. +27 (0) 12 4287911**

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 19 of 22

SANS 1833-11/ISO 1833-11, *Textiles – Quantitative chemical analysis – Part 11: Mixtures of cellulose and polyester fibres (method using sulphuric acid)*.

SANS 5278, *Sewing stitches per unit length*.

SANS 50471, *High visibility warning clothing for professional use – test methods and requirements*,

SANS 10011, *Care-labelling of textiles and clothing*.

SANS 10235, *Fibre content labelling of textiles and textile products*.

SANS 10371, *Terms and definitions for clothing*.

ANNEX A

(Normative)

Special conditions of tender

A-1 GENERAL

A-1.1 Unless otherwise stated, Transnet (or an organization deputed by it), shall be the inspecting authority.

A-1.2 Three pre-production sample slacks, shall have been inspected, tested and approved by the inspecting authority before bulk production is commenced. Each one of these samples shall be accompanied by a trim chart containing a sample of each component material (as given in section 6) and the relevant certificates. It shall be the duty of the manufacturer to give adequate notice to the inspecting authority of the availability of these samples.

A-1.3 The slacks shall be subject to inspection during the course of manufacture. The inspector shall, during normal working hours, be given all reasonable facilities for carrying out his duties and shall have the right of entry into the contractor's factory and the factory or works of any subcontractor where work on slacks supplied to this specification may be in progress

A-1.4 The contractor shall inspect the finished slacks for compliance with the specification before submitting them to the inspecting authority for final inspection.

A-1.5 Before acceptance, the slacks shall have been inspected and tested by the inspecting authority and found to comply with the requirements of the specification.

A-2 DOCUMENTATION

One container of each consignment shall be marked "DOCUMENTS" and in addition to the slacks, shall contain the following:

- a) The packaging slip or delivery note;
- b) where applicable the inspection certificate(s);
- c) a copy of the invoice containing the following information:
 - the order number
 - the financial authority number
 - a full description of the consignment, i.e. Item number, quantity, etc

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 20 of 22

ANNEX B
(Normative)
CKS 129 Colours

Due to the fact that colours can change over a period of time, any colour standard which has been registered for a period of SEVEN YEARS or more shall be considered obsolete. These standards shall then be allocated an archived status (as opposed to current status) and re-registration shall be required.

A. The following scenarios require a submission of three metres of fabric and/or a reel of embroidery thread from the successful tenderer:

1. A colour standard is archived.
2. First time registration is required (CKS 129 colour number does not exist).
3. Colour swatch stock at the SABS is no longer available.

B. Requirements for the submission of fabric as identified in A:

1. The colour shall be as agreed upon between Transnet and the successful tenderer.
2. The fabric and embroidery thread shall be used to make new colour swatches which shall be the responsibility of the SABS.
3. The cost of the three metres of fabric and embroidery thread shall be incorporated in the relevant tender submission.

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 21 of 22

HISTORY SHEET				
VERSION	DATE	AMENDMENTS/HISTORY	CHECKED	
			NAME	INIT.
01.0	June 2012	First release		

ORIGINAL

Doc No	Date	Responsibility	Version	Page
CSS 286.21 G160	June 2012	Transnet	01.0	Page 22 of 22